

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005280**Date Inspected:** 10-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

CWIs: Mr. Wu Zhi Feng, Mr. Sun Wei

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Paul Dawson arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay 9

This QA Inspector observed ZPMC welder Mr. Jiang Ting Quang, stencil 062265 is using the flux cored welding procedure WPS B-T-2232-TC-U5F to make repairs to OBG deck plate DP608-001 weld #13. Prior to welding the QA Inspector observed the base material was preheated using a torch. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Zhao Cheng Shuang, stencil 59400 is using the flux cored welding procedure WPS-345-FCAW-2G(2F)-repair-1 to make repairs to OBG deck plate DP565-001 welds. Prior to welding the QA Inspector observed the base material was preheated using a torch. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Ms. Shao Ming Zho, stencil 59448 is using the flux cored welding procedure WPS-B-T-2232-TC-U5-F to tack weld OBG deck plate DP585-001 welds. Prior to welding the QA

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Inspector observed the base material was preheated using a torch. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

OBG Bay 2

This QA Inspector performed random final visual inspections of tower double diaphragm welds NSD1-SA196-BB welds 1 through 16, NSD1-SA196-B/B welds 9 through 10, 13 through 16 and NSD1-SA265 weld 1 and 2 in support of ZPMC's request for issuing a green tag release. These welds have previously been inspected and accepted by ZPMC Quality Control personnel. The QA Inspector observed the welds appear to comply with project specifications.

OBG Bay 9

This QA Inspector observed two ZPMC welders Mr. Li Zhao qian, stencil 048810 and Mr. Xin Ming, stencil 053742 are using the flux cored welding procedure WPS B-T-2132-3 to weld stiffener plates on OBG deck plate DP565-001. The QA Inspector observed the base material had previously been preheated using electrical heaters. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
